

Date: Monday, 2/27/2006 4:21:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY
 Job Number : 25991
 Estimate Number : 10257
 P.O. Number : N/A Part Number : D212664201
 This Issue : 2/27/2006 S.O. No. : N/A Drawing Number : D212-664-241 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B
 Previous Run : 25990 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 3/15/2006 Qty: 1 Um: Each
 Checked & Approved By : 06.02.28
 Comment : Est Rev:E 04.02.16 Reformat K/DS

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

KT 06.03.02

2.0 D6006129 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube B22765

Check OD = 3.250"; ID = 2.220"

BG 06.03.08

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114 M8 06/03/09

2-Turn first side as per Folio FA114 M8 06/03/09

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. M8 06/03/09

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

M8 06/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:21:02 PM
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Job Number: 25991

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Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

M8 06/03/09

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. M8 06/03/09

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

M8 06/03/09

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EP - 6/03/09

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

M8 06/03/09

2-Remove sand and plugs

M8 06/03/09

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

M8 06/03/09

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

M1 06/03/17 (1)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-3-18

(1)

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

DP 06-3-20 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 25991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



206-03-27

Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

Pm '06-03-29 (1)

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

Pm '06-03-29 (1)

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

Pm '06-03-29 (1)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

FL 06-03-30 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-03-30

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 00000920

206-03-31

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

1

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

206-04-12

(1)

18.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

206-04-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 25991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

FC 06 06 01 (1)

2-Paint outside crosstube with White Imron as per QSI 005 4.2

M 06 06 03 (1)

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

06-06-06 (1)

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total: 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip 324328 25 06-06-06

22.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support 325594 25 06-06-06

23.0

MS2192028

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp M100479 25 06-06-06

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8582

RT 06-06-06

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

RT 06-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 25991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26-06-07 (1)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

1 D3428-1 PLACARD

B26018

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN6-40A

Bolt

M19099

29.0

AN641A

Bolt



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN6-41A

BOLT

M19633

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 ~~16~~ AN960JD616

Washer

M100191

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

6 MS21042L6

Nut (or -6)

M19099

26/6/2

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 25991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206/07/06 (1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

Per B 206/6/2 (1)

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206/06/08 (1)

Job Completion



U 06.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25991
Description: Crosstube Assembly (205/212 High Aft)		Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: A3 B PH 05.02.03		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.990	+0.005/-0.000	2.994	✓			
	5.237 PH 05.02.03	+/-0.001 +0.001/-0.000	5.237	✓			
	2.600	+0.005/-0.000	2.602	✓			
	2.686	+0.005/-0.000	2.689	✓			
	2.770	+0.005/-0.000	2.773	✓			
	2.854	+0.005/-0.000	2.856	✓			
	2.938	+0.005/-0.000	2.940	✓			
	3.021	+0.005/-0.000	3.023	✓			
	3.133	+0.005/-0.000	3.135	✓			
	3.179	+0.005/-0.000	3.178	✓			
SIDE B	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.990	+0.005/-0.000	2.994	✓			
	5.237 PH 05.02.03	+/-0.001 +0.001/-0.000	5.237	✓			
	2.600	+0.005/-0.000	2.603	✓			
	2.686	+0.005/-0.000	2.690	✓			
	2.770	+0.005/-0.000	2.774	✓			
	2.854	+0.005/-0.000	2.858	✓			
	2.938	+0.005/-0.000	2.942	✓			
	3.021	+0.005/-0.000	3.025	✓			
	3.133	+0.005/-0.000	3.134	✓			
	3.179	+0.005/-0.000	3.180	✓			
	124.36	+/-0.020	124.375	✓			

Measured by: BG / MS	Audited by: EF	Prototype Approval:	N/A
Date: 06/03/09	Date: 06/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.09 [Signature]

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

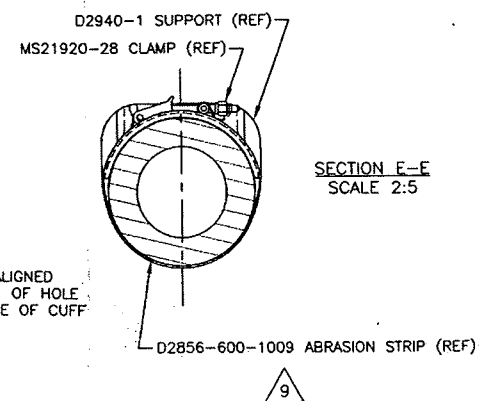
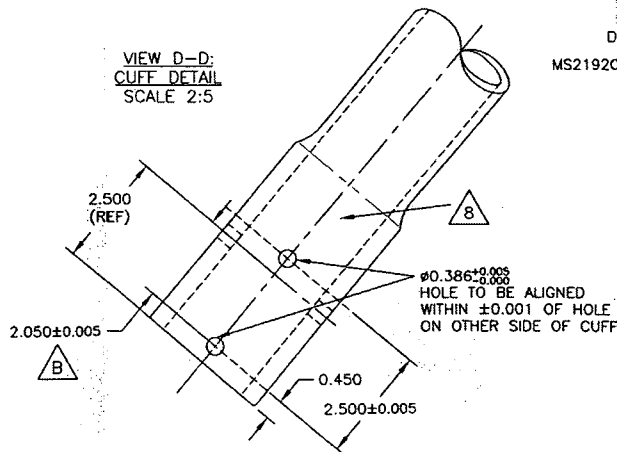
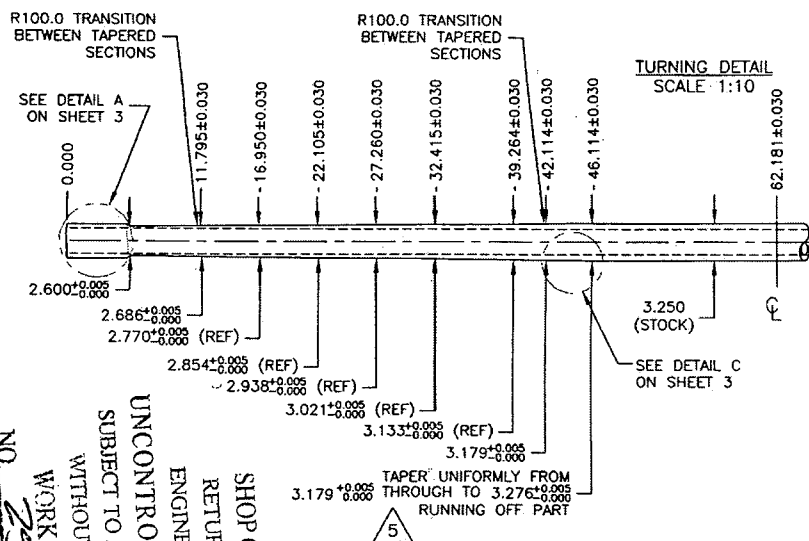
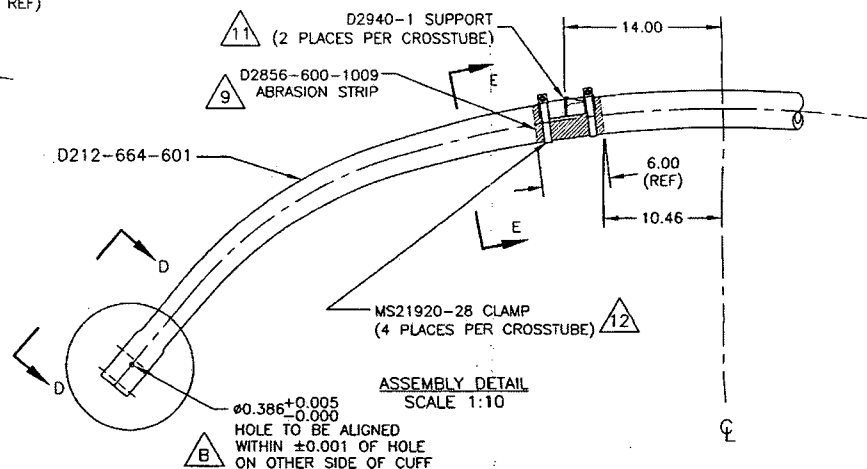
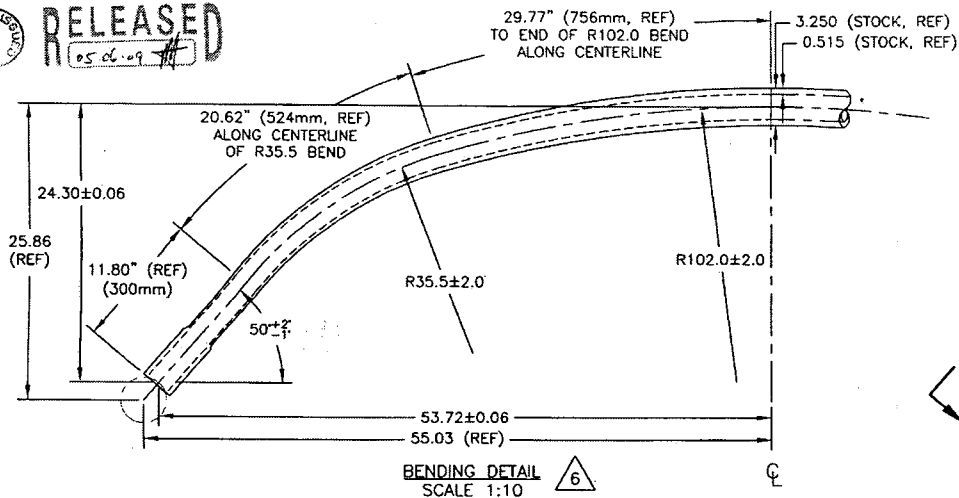
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WORK ORDER
NO. 25991

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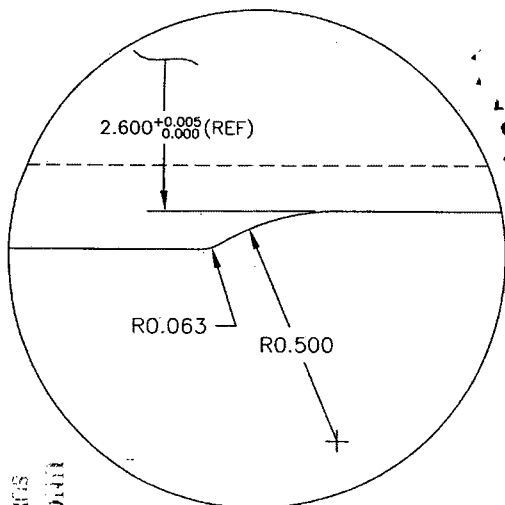
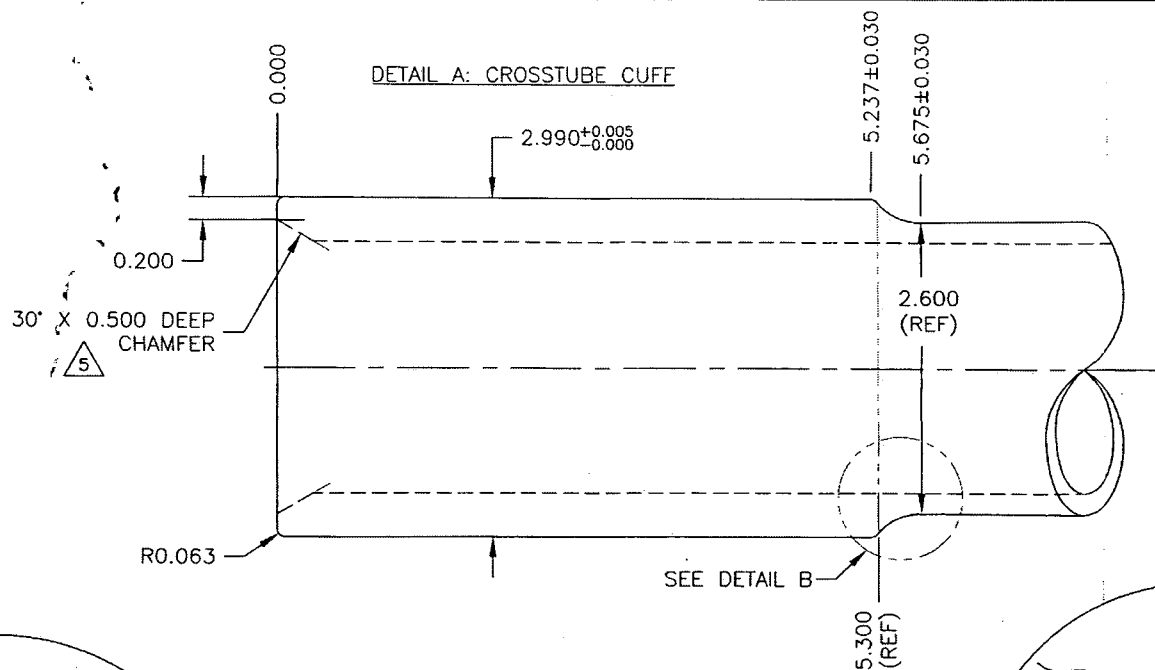
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05.02.04



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		DATE	05.02.04	TITLE		CROSSTUBE ASS'Y (205/212 HI AFT) 1:10	

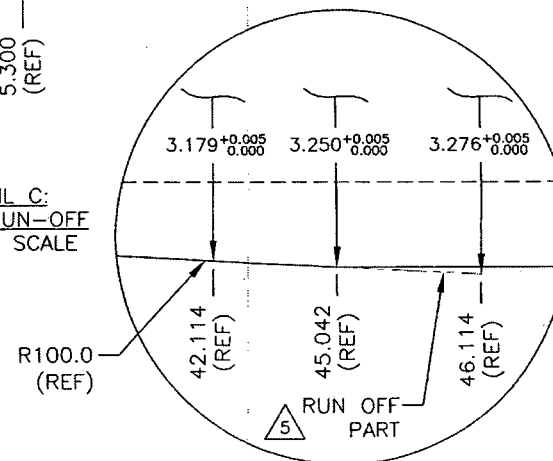
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05-06-09



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



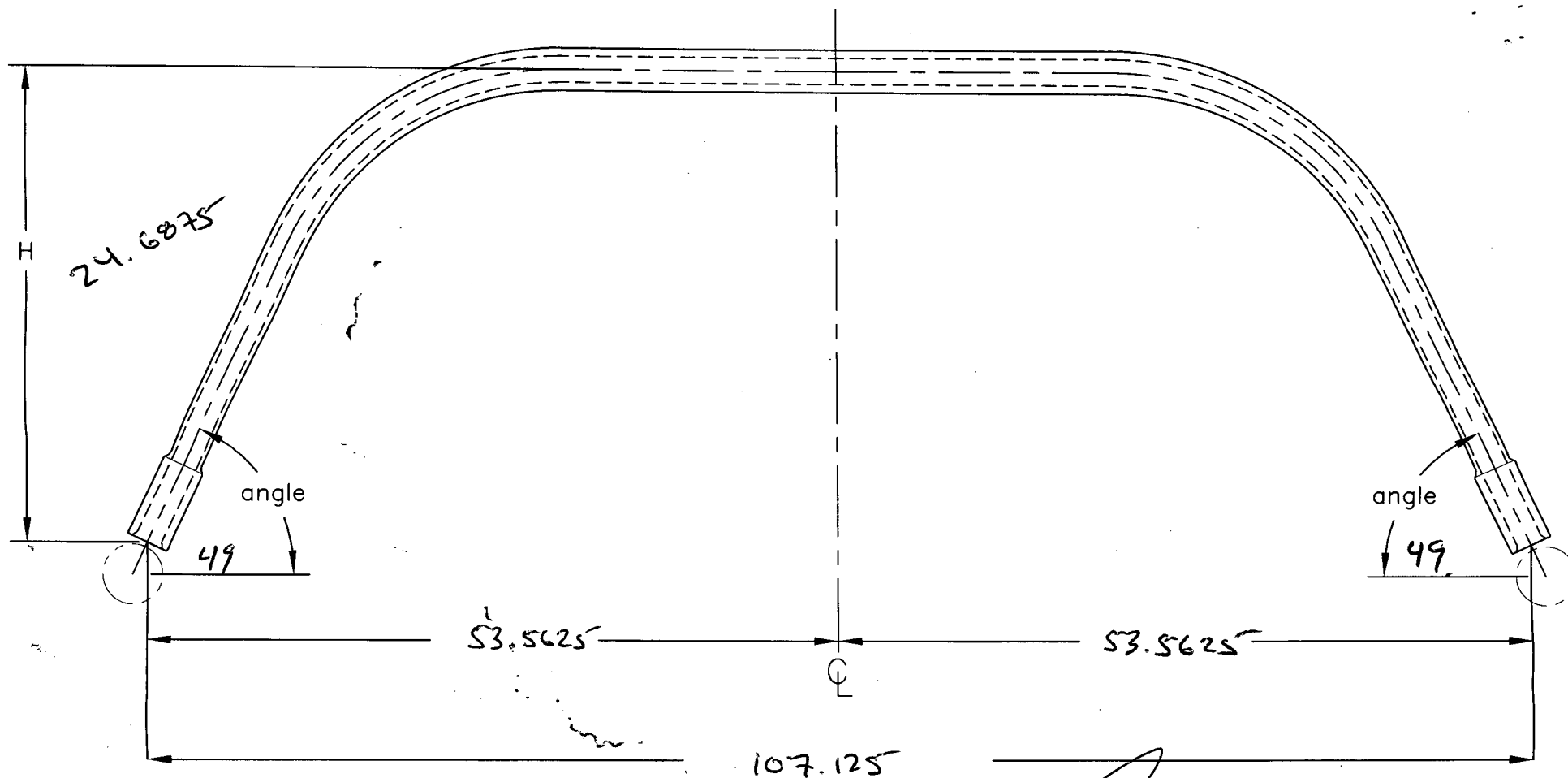
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DESIGN FH	DRAWN BY FH	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D212-664-241	REV. B SHEET 3 OF 3
DATE 05.02.04	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:1	

WORK ORDER
25991

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SUBJECT TO AMENDMENT
WITH NOTICE
RETURN TO
ENGINEERING
SHIP COPY



DATE: 06-03-20

DESCRIPTION: 212-664-201

BATCH NO: 25591

DRAWING: 212-664-241 Rev. B

H: 24.30

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50°

$\pm .060$

06-03-27
See e-mail

4. 10. 11.

3. 10. 11.

3. 10. 11.

3. 10. 11.

3. 10. 11.

Jason Murdoch

From: David Shepherd [davids@dartaero.com]
Sent: March 27, 2006 1:31 PM
To: Jason Murdoch
Subject: Re:

Sorry for the delay Jason. D212-664-201 B25991 is acceptable.

David

----- Original Message -----

From:
To:
Sent: Thursday, March 23, 2006 2:32 PM

Is this good to go? What do you think of the height? It's very rare that the tubes are to dwg on this dim.

3/27/2006

**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lapine, Dorval, Québec H9P 1G3

Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 33877

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (3) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D212-664-201 S/N's B25993, B25991 and B25995.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (3) Cross Tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

(3) cross tubes inspected. (3) PASSED inspection / (0) FAILED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE April 4, 2006

INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER PO00000920

ADDRESS:

CONTACT NAME: Linda

LABOUR

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

\$

GST

PST

INVOICE NO.

TOTAL \$